

Work Order ID 84194

84194

May-07-12 11:21:33 AM

Page 1

Item ID: D4149-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Spacer

Stop *NS2*

Start Date: 07/05/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4149

C

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

4.00" LONG

SL 12-05-17

12

110

0.00

110

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA942 AND DWG

FOLIO REV: AA

DWG REV: C

DEBURR

SL 12-06-05

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84194

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 07/05/2012 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 23/05/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

SL 12-06-05

120

QC

Memo

0.00

Quality Control

0.00

ank 12/06/05

130

OC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: S J 10 Z 0.00

170

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
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Page 3

Accept

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 07/05/2012 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

mf
12-06-04

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

May-07-12 11:21:39 AM

Page 1

Work Order ID: 84194

84194

Parent Item: D4149-3

D4149-3

Parent Item Name: Spacer

Start Date: 07/05/2012

Required Date: 23/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD IPP
Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X1.000		Purchased	No			100	f	12.2505	0.33333333	4.210526			

M303B1 000X1 000

303 BAR 1" X 1"

**

22 12-05-17

Location

Loc Qty

Loc Code

MAT050

12.250526

120602

12.250526

4.211

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

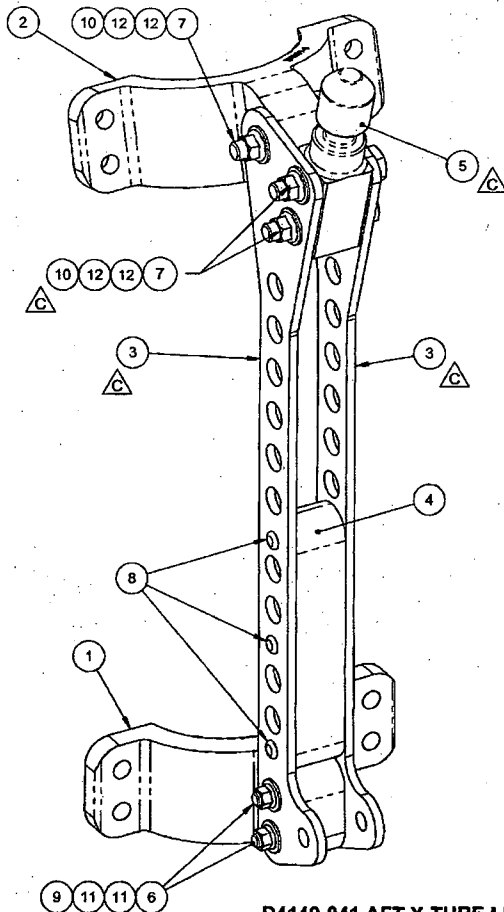
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D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 84194 MCT
12/05/07

RELEASED
2011-02-26
JW

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C9-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (C9-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.125 3 PL (ZN D8-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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AN4C13A BOLT
NAS1149C0432R WASHER, 2X
MS21043C4 NUT
3PL

D4149-5
EYEBOLT STUD

MS20615-4M18
RIVET
3 PL

D4149-041 AFT X-TUBE LUG ASSY

D4091-1
MOUNTING LUG

D4149-1
AFT X-TUBE LUG PLATE
2 PL

D4149-3
SPACER

AN3C12A BOLT
NAS1149C0332R WASHER, 2X
MS21043C3 NUT
2 PL

D3910-1
X-TUBE LUG

RELEASED
2011-02-24

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4149	SHEET 2 OF 5
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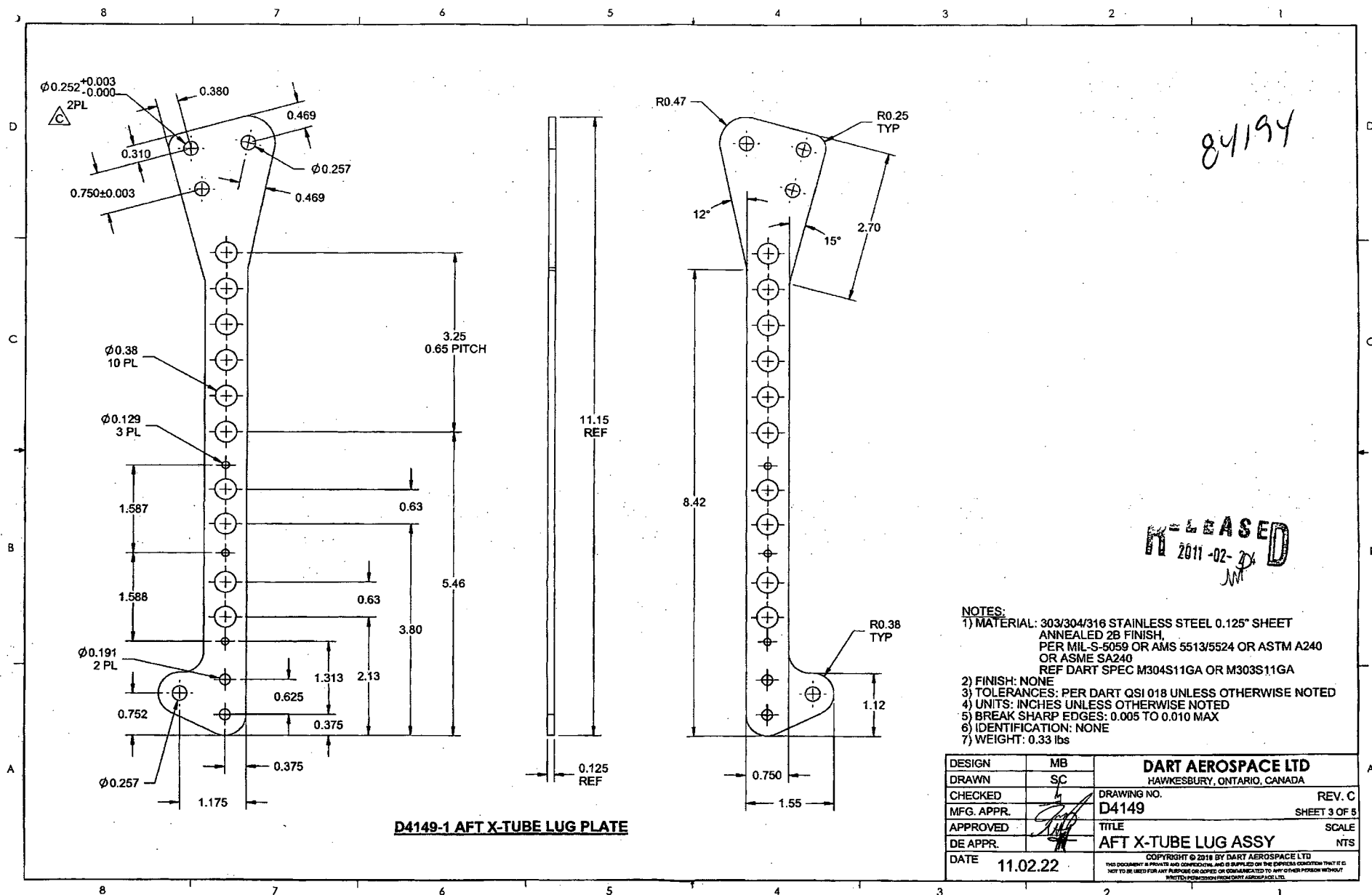
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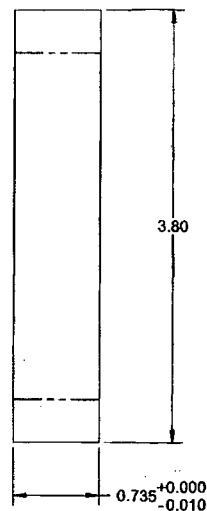
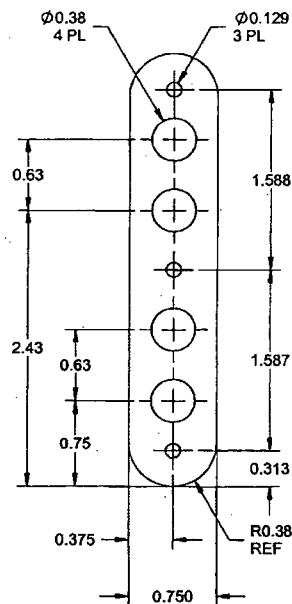
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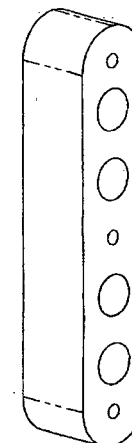
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NOTE: Date & initial all entries



D4149-3 SPACER

84194



RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESSBURY, ONTARIO, CANADA	
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MFG. APPR.		D4149	SHEET 4 OF 5
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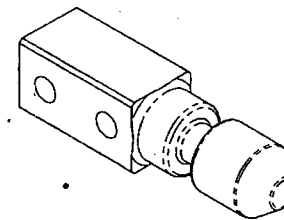
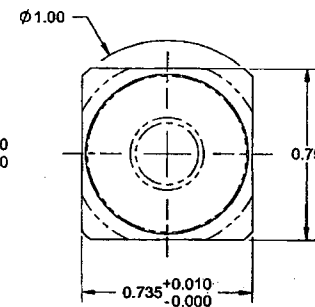
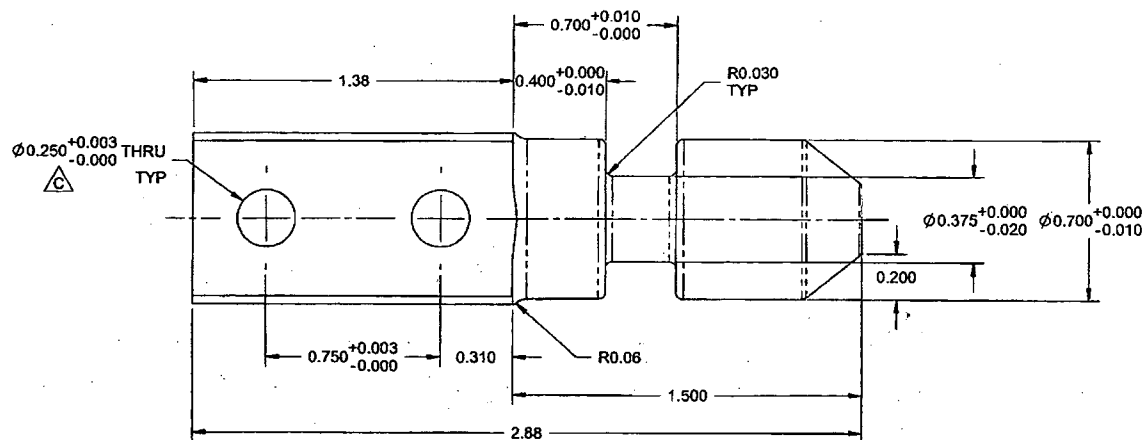
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84194

D4149-5 EYEBOLT STUD

RELEASED
2011-02-23

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 LBS

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4149	SHEET 5 OF 5
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